



Dart Aerospace Ltd.
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D2620

Job Sheet 172074



Part No: D2620

Job Qty: 20 ea

Part Name: Skidtube, 206 Skidtube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/19/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP D 02.07.26 Change Dwg to rev.B; Updated Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		2/17/18	0.00	0.00	Start Up Skidtubes-2		
100	Skidtubes	20 pcs		2/19/18	0.10	5.26	Skidtubes-3		
110	QC	20 pcs		2/19/18	0.00	0.00	QC5		
120	Packaging	20 pcs		2/19/18	0.00	0.00	Packaging3-1		
130	QC21-SA	20 Ea		2/19/18	0.00	0.00	QC21		

Part Op 100 - 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2- Cut Fwd end
Descriptions: of tube as per Dwg D2620
120 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-1-160	Extrusion Round 3" 206	20 Ea (1 ea)	90-Start up Operation	13/41 207

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-1-160	20	31	0

Part Specifications

Specifications could not be found.

Plex 2/14/18 2:59 PM Dart.Gagnon.Michelle

DARI
AEROSPACE

Container No: S108902



Part: D2620

Job No: 172074

Serial No/Batch: S1089

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

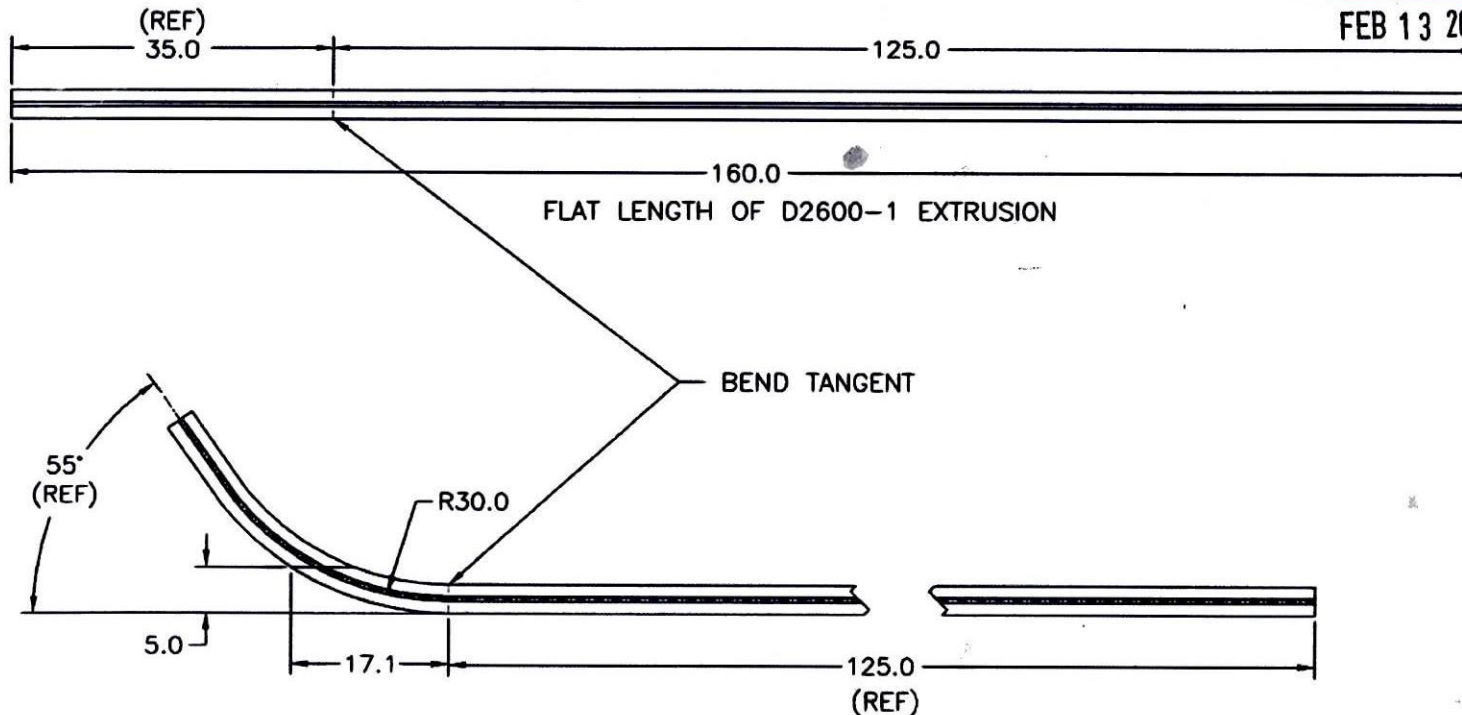
SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172074

FEB 13 2018

DART



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. *3.0 to 3.4*
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE. *3.190 to 3.210*
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. *2.950 to 3.350*
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. *3.160 to 3.140*

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
49.04.15

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE		TITLE
99.09.10		206 SKIDTUBE BENDING CONTROL
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
		SCALE
		1:20
		REV. B
		SHEET 1 OF 1